



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada  
Tel (613) 632-5200

**D350-591-311**  
**Job Sheet 173610**



Part No: D350-591-311

Job Qty: 10 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/5/18

Job Tracking No:

Due Date: 7/20/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

## Bill of Materials

## Job Routing

| Op No | Operation          | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off     |
|-------|--------------------|--------|------------|----------|-----------|---------|-----------------------|-----------|--------------|
|       |                    |        |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |              |
| 90    | Start up Operation | 10 Ea  |            | 7/18/18  | 0.00      | 0.00    | Start Up Large Fab-4  |           | SLU          |
| 110   | Large Fab          | 10 pcs |            | 7/19/18  | 0.00      | 9.91    | Large Fab 2           |           | SLU          |
| 120   | QC                 | 10 pcs |            | 7/19/18  | 0.00      | 0.00    | QC9                   |           | SLU 12-05-01 |
| 130   | QC                 | 10 pcs |            | 7/19/18  | 0.00      | 0.00    | QC5                   |           | SLU 18-05-01 |
| 140   | HandFinish         | 10 pcs |            | 7/19/18  | 0.00      | 1.84    | HandFinish1           |           | SLU 18-05-01 |
| 150   | QC                 | 10 pcs |            | 7/19/18  | 0.00      | 0.00    | QC7-2                 |           | CPL          |
| 180   | Large Fab          | 10 pcs |            | 7/19/18  | 0.00      | 9.91    | Large Fab 2           |           | SLU          |
| 190   | QC                 | 10 pcs |            | 7/19/18  | 0.00      | 0.00    | QC10                  |           | CPL          |
| 200   | QC                 | 10 pcs |            | 7/19/18  | 0.00      | 0.00    | QC5                   |           | CPL          |
| 210   | HandFinish         | 10 pcs |            | 7/19/18  | 0.00      | 1.84    | HandFinish1           |           | SLU 18-05-08 |
| 220   | Powdercoat         | 10 pcs |            | 7/19/18  | 0.00      | 2.90    | Powdercoat1           |           | SLU 18-5-9   |
| 230   | HandFinish         | 10 pcs |            | 7/20/18  | 0.00      | 1.84    | HandFinish3           |           | SLU 18-5-10  |
| 240   | QC                 | 10 pcs |            | 7/20/18  | 0.00      | 0.00    | QC3                   |           | SLU          |
| 250   | Packaging          | 10 pcs |            | 7/20/18  | 0.00      | 0.00    | Packaging1-3          |           | SLU          |
| 260   | QC                 | 10 pcs |            | 7/20/18  | 0.00      | 0.00    | QC4                   |           | SLU          |
| 265   | DC                 | 10 pcs |            | 7/20/18  | 0.00      | 0.00    | DC                    |           | SLU          |
| 270   | Packaging          | 10 pcs |            | 7/20/18  | 0.00      | 0.00    | Packaging3-1          |           | SLU          |
| 280   | QC21-FG            | 10 Ea  |            | 7/20/18  | 0.00      | 0.00    | QC21                  |           | SLU          |

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod M38673 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod M38673 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 11:30 OVEN TEMPERATURE: 320° FINISH TIME: 12:00

265 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

5064697 (X5LH)

## Job BOM

| Part / Item   | Component Name            | Quantity       | Operation             | Container         |
|---------------|---------------------------|----------------|-----------------------|-------------------|
| D3067-1       | End Plate                 | 20 Ea (2 ea)   | 90-Start up Operation | 5047606 / 5059392 |
| D3219-1       | Plate                     | 20 Ea (2 ea)   | 90-Start up Operation | 5047607 / 5064695 |
| D3272-1       | Step                      | 10 Ea (1 ea)   | 90-Start up Operation | 5064694           |
| D3065-041     | Step Leg Assembly         | 10 Ea (1 ea)   | 180-Large Fab         | 5069163           |
| D3066-1       | Spacer                    | 20 Ea (2 ea)   | 180-Large Fab         | 5051986           |
| MS20600-AD4W4 | Rivet                     | 160 Ea (16 ea) | 180-Large Fab         | 5041171           |
| AN3-35A       | Bolt                      | 20 Ea (2 ea)   | 250-Packaging         | 5062324           |
| AN4-13A       | Bolt                      | 80 Ea (8 ea)   | 250-Packaging         | 5048292           |
| AN5-36A       | Bolt                      | 20 Ea (2 ea)   | 250-Packaging         | 5066278           |
| D2230-3       | Mounting Lug              | 40 Ea (4 ea)   | 250-Packaging         | 5049835           |
| D2618         | Bushing                   | 20 Ea (2 ea)   | 250-Packaging         | 5049550           |
| D2856-400-720 | Abrasion Strip 4" X 7.20" | 20 Ea (2 ea)   | 250-Packaging         | 5053650           |
| D3235-1       | Mounting Lug              | 20 Ea (2 ea)   | 250-Packaging         | 5067940           |
| D3278-041     | Support Assembly          | 10 Ea (1 ea)   | 250-Packaging         | 5062384           |
| MS21042L3     | Nut                       | 20 Ea (2 ea)   | 250-Packaging         | 5054118           |
| MS21042L4     | Nut                       | 80 Ea (8 ea)   | 250-Packaging         | 5041167           |
| MS21042L5     | Nut                       | 20 Ea (2 ea)   | 250-Packaging         | 505269            |
| NAS1149D0363J | Washer                    | 40 Ea (4 ea)   | 250-Packaging         | 5055952           |
| NAS1149D0463J | Washer                    | 160 Ea (16 ea) | 250-Packaging         | 5059030           |
| NAS1149D0563J | Washer                    | 40 Ea (4 ea)   | 250-Packaging         |                   |

## Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | D3067-1        | 20       | 41        | 0         |
|                       | D3219-1        | 20       | 55        | 0         |
|                       | D3272-1        | 10       | 0         | 0         |
| 180-Large Fab         | D3065-041      | 10       | 22        | 0         |
|                       | D3066-1        | 20       | 10        | 0         |
|                       | MS20600-AD4W4  | 160      | 1,681     | 0         |
| 250-Packaging         | AN3-35A        | 20       | 312       | 0         |
|                       | AN4-13A        | 80       | 941       | 0         |
|                       | AN5-36A        | 20       | 148       | 0         |
|                       | D2230-3        | 40       | 65        | 0         |
|                       | D2618          | 20       | 214       | 0         |
|                       | D2856-400-720  | 20       | 197       | 0         |
|                       | D3235-1        | 20       | 6         | 0         |
|                       | D3278-041      | 10       | 7         | 0         |
|                       | MS21042L3      | 20       | 3,284     | 0         |
|                       | MS21042L4      | 80       | 3,884     | 0         |
|                       | MS21042L5      | 20       | 849       | 0         |
|                       | NAS1149D0363J  | 40       | 3,378     | 0         |
|                       | NAS1149D0463J  | 160      | 5,081     | 0         |
|                       | NAS1149D0563J  | 40       | 1,290     | 0         |

## Part Specifications

Specifications could not be found.

Plex 3/5/18 4:05 PM Dart.Gagnon.Michelle

003/48



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**Container No: S064697**



**Part: D350-591-311**

**Job No: 173610**

**Serial No/Batch: S064697**

**Revision:**

**Inspector:**

Date: 04/24/18





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## Container View (Active) - Master Unit Containers

| Master Unit No | Container No | Part No       | Part Name                 | From Container | Current Location | Quantity |
|----------------|--------------|---------------|---------------------------|----------------|------------------|----------|
| 003142         | S070062      | AN3-35A       | Bolt                      | S047324        | ST348            | 10       |
| 003142         | S070061      | AN4-13A       | Bolt                      | S062374        | ST344            | 40       |
| 003142         | S070060      | AN5-36A       | Bolt                      | S048292        | ST336            | 10       |
| 003142         | S070059      | D2230-3       | Mounting Lug              | s066272        | ST521            | 20       |
| 003142         | S070058      | D2618         | Bushing                   | s043411        | ST008            | 10       |
| 003142         | S070055      | D2856-400-720 | Abrasion Strip 4" X 7.20" | S046950        | ST418            | 10       |
| 003142         | S070054      | D3235-1       | Mounting Lug              | s053650        | ST522            | 10       |
| 003142         | S070052      | D3278-041     | Support Assembly          | s067940        | ST522            | 5        |
| 003142         | S070051      | MS21042L3     | Nut                       | S062377        | GA011            | 10       |
| 003142         | S070050      | MS21042L4     | Nut                       | S054118        | ST303            | 40       |
| 003142         | S070049      | MS21042L5     | Nut                       | S041167        | ST303            | 10       |
| 003142         | S070048      | NAS1149D0363J | Washer                    | S015269        | ST263            | 20       |
| 003142         | S070047      | NAS1149D0463J | Washer                    | s055952        | ST263            | 80       |
| 003142         | S070046      | NAS1149D0563J | Washer                    | s039036        | ST263            | 20       |

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 5/10/18 9:21 AM dart.quirion.sonia

## Change Record

PAGE 1 OF 1

**Part Number:** D350-591-311/-312 (EURO P/N: 704A 41 640 012/-011)

**Description:** HELI-ACCESS STEP, HIGH SKID, LONG STEP, LH/RH

[illegible]